

Ship 28-31/08

Work Order ID 51685

August 27, 2009 9:42:46 AM



Page 1

Item ID: D3881-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 8/27/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3881

Dwg Rev: *A*

Prog Rev: *A*

grain along 3.75"

2- Deburr if necessary

6061 .063

RB 9-8-08

(S)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 9-8-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg
2- Bend as per dwg
3- deburr

7 m. h 09/08/31
7 m. h 09/08/31 Deburr

5X

φ

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/27/09/31

5X

φ

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

0.00

Memo

09-08-31

(5)

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

09/08/31

(5)

Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location:

139

0.00

0.00

Memo

09/08/31 (5)

W/O:		WORK ORDER CHANGES					
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Page 4

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Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/31 *[Signature]*
MF 09-08-31

W/O:		WORK ORDER CHANGES					
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Picklist Print

August 27, 2009 9:42:45 AM

Page 1

Work Order ID: 51685

Parent Item: D3881-1RevA

Parent Item Name: Bracket


Comments:

Start Date: 8/27/09

Required Date: 8/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	119.0671	0.1600			
												
6061-T6 .063 Sheet												

B 9-8-09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	119.0671211	
109463	-0.0223	
110551	119.089421	

NO SS

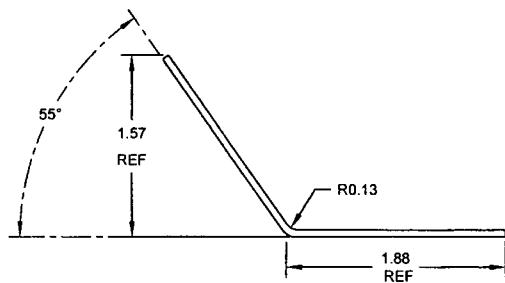
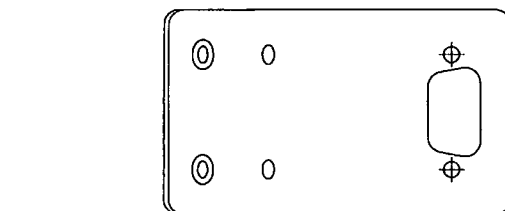
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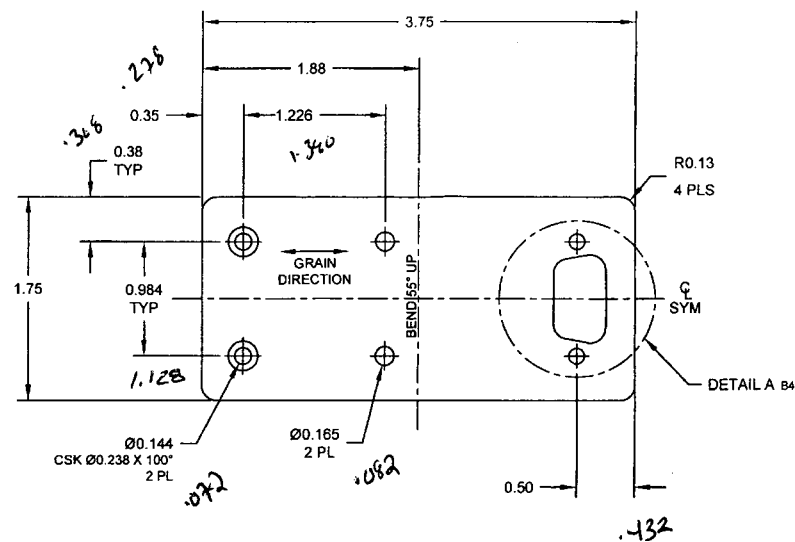
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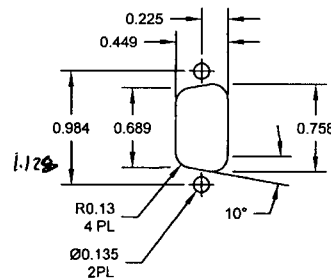


D3881-1 BRACKET
(MAKE FROM D3881-1F)

*W/D
51685*



D3881-1F BRACKET
(FLAT PATTERN)



DETAIL A C2

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/11 (REF DART SPEC M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3881-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

RELEASED
09/05/05 NIP

A NEW ISSUE		KB	09.01.22
REV.	DESCRIPTION		BY DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KB		
CHECKED	DD	DRAWING NO.	REV. A
MFG. APPR.	DD	D3881	SHEET 1 OF 1
APPROVED	DD	TITLE	SCALE
DE APPR.	DD	CONFIG AND MAINT. PORT BRACKET	NTS
DATE		09.01.22	

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